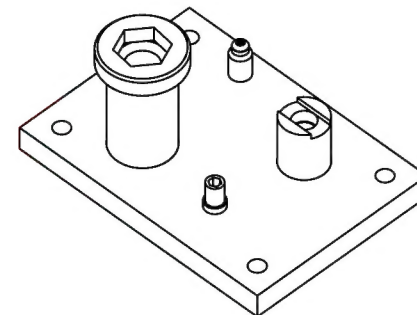
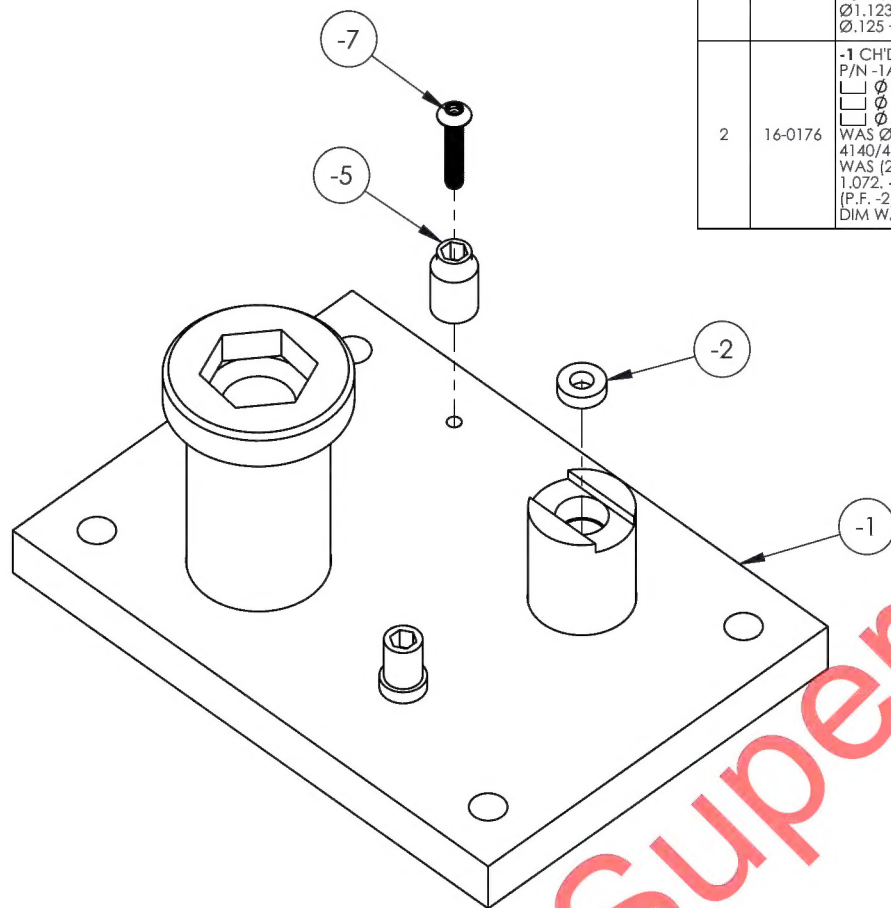


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-9 ADDED. -7 ADDED P/N TO BOM. -1 ADDED WELDMENT. -1A CH'D DIA. WAS Ø.780 IS Ø.880 THRU. CH'D DIA. WAS Ø1.500 IS Ø1.501. -1B CH'D DIA. WAS Ø.150 IS Ø.180. CH'D DIA. WAS Ø.473 IS Ø.500 +.005-.000. CH'D DIA. WAS Ø1.125 IS Ø1.125-1.126. -1C CH'D DIA. WAS Ø.125 +.001-.000. -1D CH'D DIA. WAS .880 IS .780. ADDED MISSING .12 DIM. FOR 35° ANGLE. ADDED REF. DIM. Ø1.123. -1E CH'D MATERIAL WAS 01 IS 4140. -1F CH'D OD WAS Ø1.125 IS Ø1.124-1.125. ADDED Ø.125 +.001-.000. -1G HOLE FOR -9. CH'D MATERIAL WAS 01 IS 4140.	8/5/2013	RJC	GE
2	16-0176	-1 CH'D DWG. TO SHEET METAL TOLERANCES, ADDED FINISH SPEC. QMSI-6.2.2. B.O. REV D, ADDED P/N -1A. -1A CH'D MATERIAL WAS 1018 IS A36/1018/1020. CH'D DIM'S WAS Ø.880 THRU ALL. Ø1.501/-1.500. -1B CH'D DIA. WAS Ø.150 IS Ø.180. CH'D DIA. WAS Ø.473 IS Ø.500 +.005-.000. CH'D DIA. WAS Ø1.125 IS Ø1.125-1.126. -1C CH'D DIA. WAS Ø.125 +.001-.000. CH'D DIA. WAS Ø1.123. -1D CH'D DIA. WAS .880 IS .780. ADDED MISSING .12 DIM. FOR 35° ANGLE. ADDED REF. DIM. Ø1.123. -1E CH'D MATERIAL WAS 01 IS 4140. -1F CH'D OD WAS Ø1.125 IS Ø1.124-1.125. ADDED Ø.125 +.001-.000. -1G HOLE FOR -9. CH'D MATERIAL WAS 01 IS 4140.	10/20/2016	RJC	SM



NOTE:

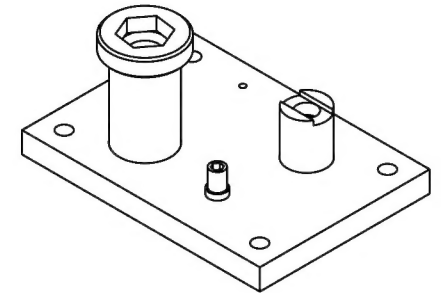
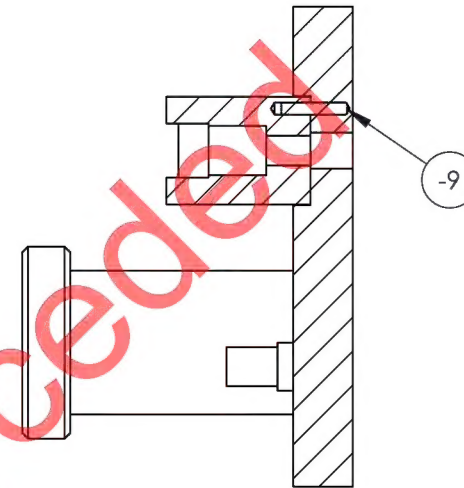
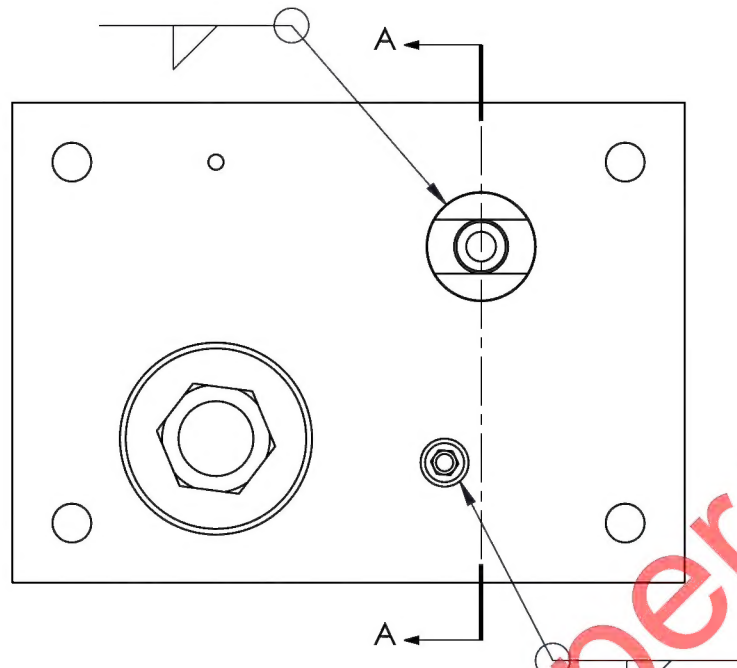
1. -5 MUST HAVE BLACK OXIDE FINISH.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	WELDMENT			2
	1		-1A		BASE	A36/1018/1020 HR		3
	1		-1B		RISER	4140/4142		4
	1		-1C		TOP	4140/4142		5
	1		-1D		RISER	4140/4142		6
			-2	1	WASHER	NYLON		7
	1	B/O	-3		SOCKET		1/4in. DR. 1/4in. X 6PT SNAP-ON IMTM8A	2
		B/O	-5	1	SOCKET		3/8in. DR. 1/4in. X 6pt (MSC #48725303)	1
		B/O	-7	1	BUTTON SOCKET HEAD CAP SCREW	STEEL	10-32 X 1 (MCMaster-CARR #91255A273)	1
	1	B/O	-9		DOWEL PIN	STEEL	Ø1/8 X 1 1/16 (MCMaster-CARR #98381A172)	2

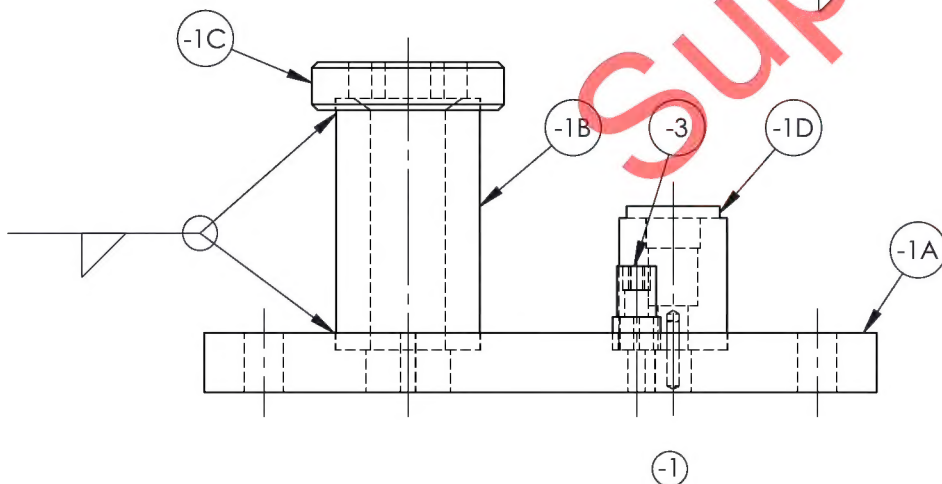
DART AEROSPACE	
TITLE FIXTURE-HOLDING FUEL NOZZLE	
DWG NO. RB6897875	REV 2
MAT'L REAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: DUERFELDT	ROLLS ROYCE
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: MACKOVJAK	
SCALE 1:2	DATE 9/16/2009
SHEET 1 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 ADDED WELDMENT.	8/5/2013	RJC	RW
2	16-0176	-1 CH'D DWG. TO SHEET METAL TOLERANCES, ADDED FINISH SPEC. QMSI-6.2.2, B.O. REV D, ADDED P/N -1A.	10/20/2016	RJC	SM



SECTION A-A

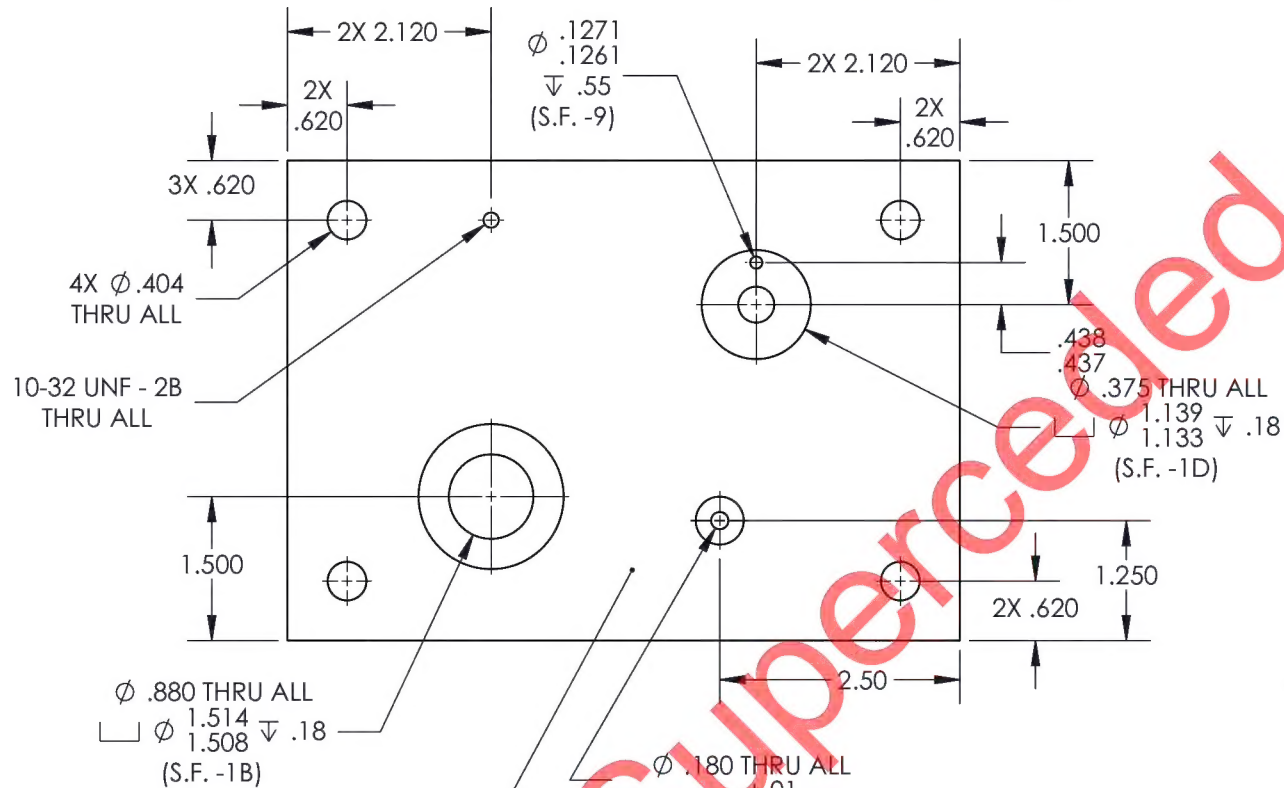


WELDMENT

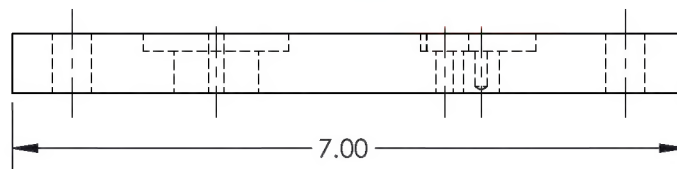
DART AEROSPACE	
TITLE FIXTURE-HOLDING FUEL NOZZLE	
DWG NO. RB6897875-1	REV 2
MAT'L ALUMINUM 6061-T6	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT BLACK OXIDE	.XXX ± .010 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .03 ANGLES ± 1°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	ROLLS ROYCE
SCALE 1:2	DATE 9/16/2009
SHEET 2 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1A CH'D DIA. WAS Ø.780 IS Ø.880 THRU. CH'D DIA. WAS Ø1.500 IS Ø1.501-1.501 ∇ .18. CH'D DIA. WAS Ø.150 IS Ø.180. CH'D DIA. WAS Ø.473 IS Ø.500 +.005-.000. CH'D DIA. WAS Ø1.125 IS Ø1.125-1.126 ∇ .18. ADDED Ø.125 +.001-.000 ∇ .55 HOLE FOR -.9.	8/5/2013	RJC	RW
2	16-0176	-1A CH'D MATERIAL WAS 1018 IS A36/1018/1020. CH'D DIM'S WAS Ø.880 THRU ALL ∇ Ø1.501/-1.500 ∇ .18 IS Ø.880 THRU ALL ∇ Ø1.514/-1.508 ∇ .18, WAS Ø.375 THRU ALL ∇ Ø1.126/-1.125 ∇ .18 IS Ø.375 THRU ALL ∇ Ø1.139/-1.133 ∇ .18, WAS Ø.180 THRU ALL ∇ Ø.500 +.005/-000 ∇ .18 IS Ø.180 THRU ALL ∇ Ø.50 +.05/-00 ∇ .18, WAS .4375 IS .438/.437, WAS Ø.125 +.001/-000 IS Ø.1271/.1261, ADDED DIM 2.50.	10/20/2016	RJC	SM



ENGRAVE T/N, S/N,
"MADE IN USA"

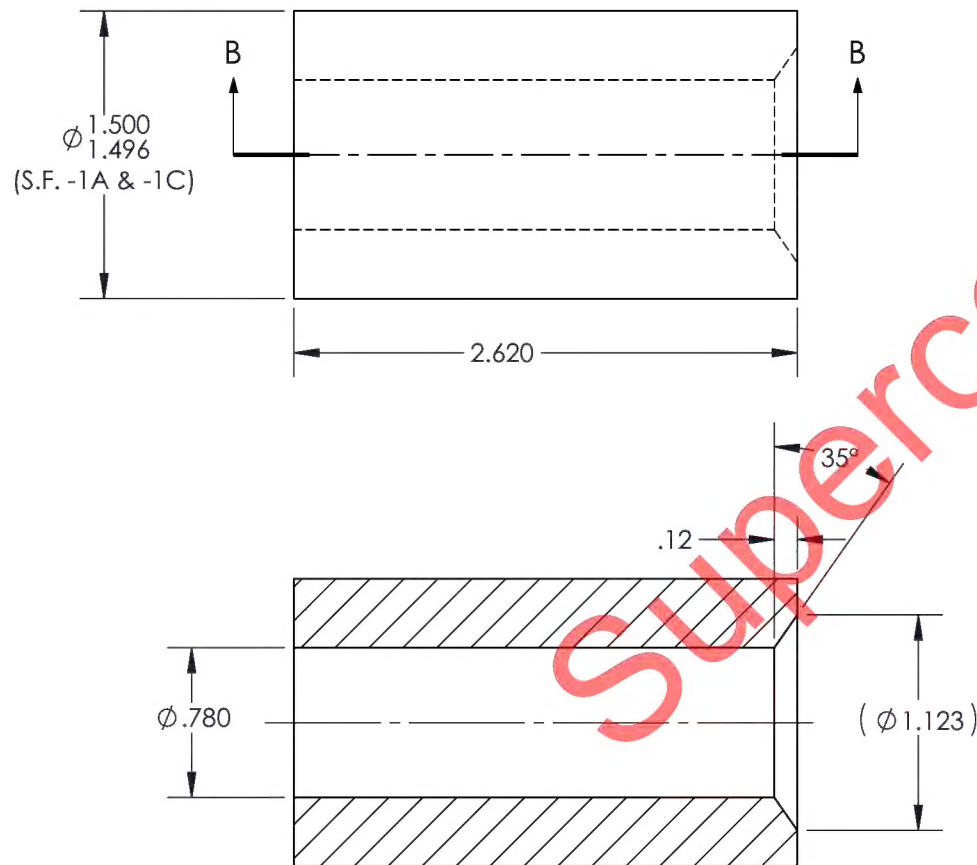


(1A)
BASE

DART AEROSPACE	
TITLE FIXTURE-HOLDING FUEL NOZZLE	
DWG NO. RB6897875-1A	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX \pm .005 FRACTIONS \pm 1/8
FINISH SEE -1 WELDMENT	.XX \pm .01 ANGLES \pm 5°
SPEC	.X \pm .1 SURFACES = 125 \sqrt
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	ROLLS ROYCE
SCALE 1:2	DATE 9/19/2009
SHEET 3 OF 7	

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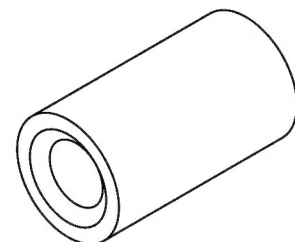
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1B CH'D DIA. WAS .880 IS .780, ADDED MISSING .12 DIM. FOR 35° ANGLE, ADDED REF. DIM. Ø1.123.	8/5/2013	RJC	RW
2	16-0176	-1B CH'D DIM WAS Ø1.500 IS Ø1.500/-1.496, CH'D MATERIAL WAS 1018 IS 4140/4142, ADDED HEAT TREAT RC 28-32.	10/20/2016	RJC	SM



SECTION B-B

(1B)

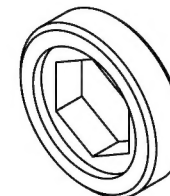
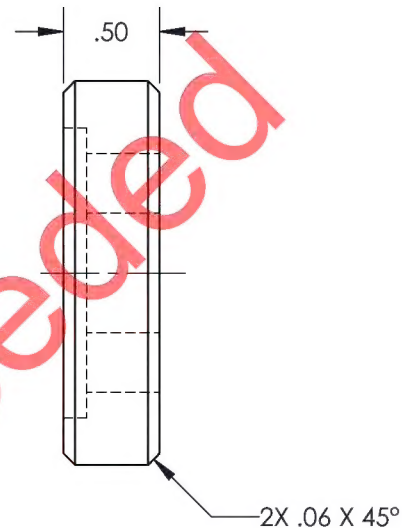
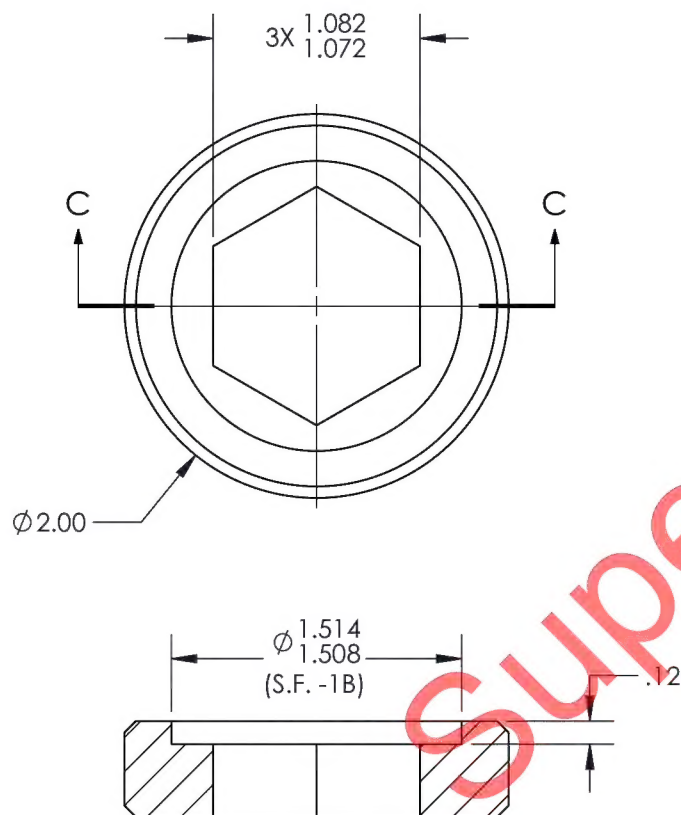
RISER



DART AEROSPACE	
TITLE FIXTURE-HOLDING FUEL NOZZLE	
DWG NO. RB6897875-1B	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 9/16/2009
	SHEET 4 OF 7

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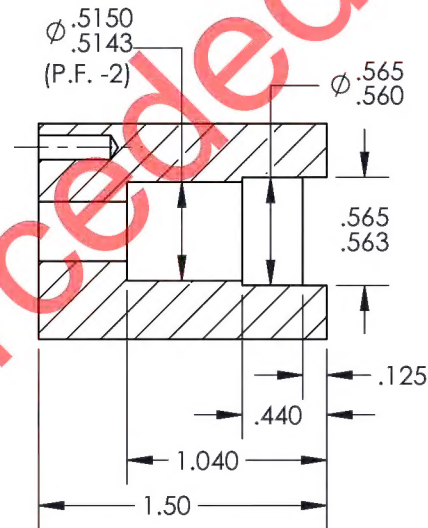
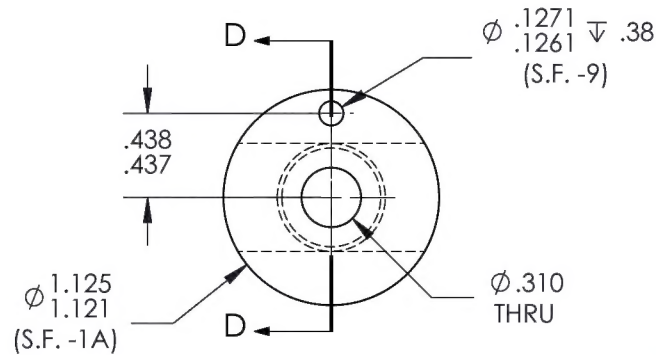
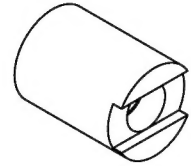
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1C CH'D MATERIAL WAS 01 IS 4140.	8/5/2013	RJC	RW
2	16-0176	-1C CH'D DIM WAS (2.00) IS 2.00, WAS Ø1.500 Ψ .120 IS Ø1.514/-1.508 Ψ .12, WAS 1.082/-1.072 HEX IS 3X 1.082/-1.072, CH'D MATERIAL WAS 4140 IS 4140/4142, CH'D HEAT TREAT WAS RC 50-54 IS RC 28-32.	10/20/2016	RJC	SM



DART AEROSPACE	
TITLE FIXTURE-HOLDING FUEL NOZZLE	
DWG NO. RB6897875-1C	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: CLOUGH	.X \pm .1 SURFACES = 125°
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: MACKOVJAK	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 9/16/2009	USED ON MODEL
SHEET 5 OF 7	ROLLS ROYCE

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1D CH'D OD WAS Ø1.125 IS Ø1.124 -1.125, ADDED Ø.125 +.001-.000 ∇ .375 HOLE FOR -9. CH'D MATERIAL WAS 01 IS 4140.	10/20/2016	RJC	GE
2	16-0176	-1D CH'D DIM WAS Ø1.125/-1.124 IS Ø1.125/-1.121, CH'D DIM WAS Ø.515 IS Ø .5150/-5143 (P.F. -2), WAS .438 IS .438/.437, WAS Ø.125 +.001/-000 ∇ .375 IS Ø.1271/.1261 ∇ .38 (S.F. -9), CH'D MATERIAL WAS 1018 IS 4140/4142, ADDED HEAT TREAT RC 28-32.	10/20/2016	RJC	SM



SECTION D-D



RISER

DART AEROSPACE	
TITLE FIXTURE-HOLDING FUEL NOZZLE	
DWG NO. RB6897875-1D	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: CLOUGH	.X \pm .1 SURFACES = 125° ✓
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: MACKOVJAK	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 9/16/2009	USED ON MODEL
SHEET 6 OF 7	ROLLS ROYCE

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0176	-2 CH'D DIM WAS Ø.515 IS Ø.5159/-.5155 (P.F. -1D).	10/20/2016	RJC	SM

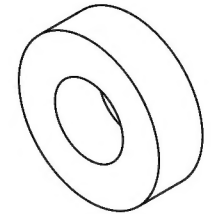
Ø.5159
Ø.5155
(P.F. -1D)

Ø.250

.160

(-2)

WASHER



Superceded



TITLE		FIXTURE-HOLDING FUEL NOZZLE	
DWG NO.		RB6897875-2	
REV		2	
MAT'L NYLON		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± .5°	
DRAWN BY: CLOUGH		.X ± .1 SURFACES = 125°	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: MACKOVJAK		AFTER PLATING	
SCALE 4:1		3. INTERPRET DIM AND TOL PER	
DATE 9/16/2009		ASME Y14.5M-2009	
SHEET 7 OF 7		USED ON MODEL	
		ROLLS ROYCE	